

LEXAN™ EXL9330S resin

Polycarbonate

SABIC Innovative Plastics Europe

Message:

Opaque PC-Siloxane copolymer with excellent processability. UV stabilized. UL rated V-0/5VA/CTI-PLC-2. Available in limited colors; please contact your SABIC IP representative

General Information			
Additive	UV stabilizer		
Features	Copolymer		
	Workability, good		
Appearance	Opacity		
	Available colors		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	8.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	7.00	cm³/10min	ISO 1133
Molding Shrinkage			Internal method
Flow: 3.20mm	0.40 - 0.80	%	Internal method
Transverse flow: 3.20mm	0.40 - 0.80	%	Internal method
Water Absorption			ISO 62
Saturated, 23°C	0.12	%	ISO 62
Equilibrium, 23°C, 50% RH	0.050	%	ISO 62
Outdoor Suitability	f1		UL 746C
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2150	MPa	ASTM D638
--	2150	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	59.0	MPa	ASTM D638
Yield	59.0	MPa	ISO 527-2/50
Fracture ³	58.0	MPa	ASTM D638
Fracture	58.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/50
Fracture ⁵	100	%	ASTM D638

Fracture	100	%	ISO 527-2/50
Flexural Modulus			
50.0mm span ⁶	2150	MPa	ASTM D790
-- ⁷	2150	MPa	ISO 178
Flexural Stress			
--	86.0	MPa	ISO 178
Yield, 50.0mm span ⁸	86.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹			ISO 179/1eA
-30°C	50	kJ/m ²	ISO 179/1eA
23°C	70	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength ¹⁰			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Notched Izod Impact			
-50°C	450	J/m	ASTM D256
-30°C	550	J/m	ASTM D256
23°C	700	J/m	ASTM D256
-30°C ¹¹	50	kJ/m ²	ISO 180/1A
23°C ¹²	75	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ¹³			ISO 180/1U
-30°C	No Break		ISO 180/1U
23°C	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	139	°C	ASTM D648
0.45 MPa, unannealed, 100 mm span ¹⁴	139	°C	ISO 75-2/Be
1.8 MPa, unannealed, 3.20mm	126	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁵	126	°C	ISO 75-2/Af
Vicat Softening Temperature			
--	147	°C	ASTM D1525, ISO 306/B120 12 ¹⁶
--	145	°C	ISO 306/B50
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
RTI Elec	125	°C	UL 746
RTI Imp	110	°C	UL 746
RTI	125	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 2		UL 746
Comparative Tracking Index	250	V	IEC 60112
High Amp Arc Ignition (HAI)	PLC 0		UL 746
Hot-wire Ignition (HWI)	PLC 2		UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.800 mm	V-0		UL 94
2.00 mm	5VB		UL 94
2.50 mm	5VA		UL 94
Glow Wire Flammability Index (1.90 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature (1.00 mm)	900	°C	IEC 60695-2-13
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	217 - 293	°C	
Middle Temperature	282 - 304	°C	
Front Temperature	293 - 316	°C	
Nozzle Temperature	288 - 310	°C	
Processing (Melt) Temp	293 - 316	°C	
Mold Temperature	71.0 - 93.0	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	50 mm/min		
2.	Type 1, 50mm/min		
3.	Type 1, 50mm/min		
4.	Type 1, 50mm/min		
5.	Type 1, 50mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*3 sp=62mm		
10.	80*10*3 sp=62mm		
11.	80*10*3		
12.	80*10*3		
13.	80*10*3		
14.	120*10*4 mm		
15.	80*10*4 mm		
16.	标准 B (120°C/h), 载荷2 (50N)		

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